

Date: Wednesday, 30/07/2008 5:32:09 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT ASS'Y RH		
Job Number	: 40825			Part Number	: D412769044		
Estimate Number	: 13314			Drawing Number	: D412-769-2 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/07/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 15/08/2008 Qty: 1 Um: Each		
Previous Run	: 40824						
Written By	:						
Checked & Approved By	: JUL 08.7.31						
Comment	: Est rev A 08.05.12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
2.0	D3782045	Back Leg Assembly	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Back Leg Assembly		
	batch: B40873-3		08/08/27 FF
3.0	D3782041	Front Inboard Leg Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Front Inboard Leg Assembly		
	batch: B40870		SP
4.0	D3782044	Front Outboard Leg Assembly, RH	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Front Outboard Leg Assembly, RH		
	batch: B40872		SP
5.0	D3783041	Lateral Brace Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Lateral Brace Assembly		
	batch: B40874		SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40825

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	D3783043	Longitudinal Brace Assembly 
		<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Longitudinal Brace Assembly batch: <u>B40875</u> <span style="float: right;">SP</span>
7.0	D3783045	Angle Brace Assembly 
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Angle Brace Assembly batch: <u>B40876</u>
8.0	D3784041	Seat Support Assembly, Center 
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, Center batch: <u>B40877</u> <span style="float: right;">SP</span>
9.0	D3784043	Seat Support Assembly, LH 
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, LH batch: <u>B40878</u> <span style="float: right;">SP</span>
10.0	D3784044	Seat Support Assembly, RH 
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Support Assembly, RH batch: <u>B40879</u> <span style="float: right;">SP</span>
11.0	D37662	Front Rail, RH 
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Rail batch: <u>B40864</u> <span style="float: right;">SP</span>
12.0	D37663	Rear Rail 
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rear Rail batch: <u>B40865</u> <span style="float: right;">SP</span>

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:32:09 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT FACING SEAT ASS'Y RH
Job Number: 40825		Part Number: D412769044
Job Number:		
Seq. #:	Machine Or Operation:	Description :
13.0	D37671	Upper Rail 
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Upper Rail batch: <u>B40866</u>		50
14.0	D37921	Seat Belt Eye Bolt 
		
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Seat Belt Eye Bolt batch: <u>B40209</u> <u>B40999</u>		50
15.0	AN415A	Bolt 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt batch: <u>M104746</u>		50
16.0	AN45 13A	EYE BOLT 
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) EYE BOLT batch: <u>M109013</u>		50
17.0	AN510A	Bolt 
		
Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: <u>M108471</u>		50
18.0	AN513A	Bolt 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt batch: <u>M108167</u>		50
19.0	AN960JD10	Washer 
		
Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s) Washer batch: <u>M109059</u> (or NAS1149D0363J) batch: <u>M109059</u>		FF 08/08/27 

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40825

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108161

(or NAS1149D0463J) batch:

54

21.0 AN960JD516 Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s) (9)

Washer

batch: M108246 (11)

(or NAS1149D0568J) batch:

54

22.0 AN52510R24 Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108270

54

23.0 MS21042L3 Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M108701

54

24.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107499

54

25.0 MS21042L5 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: 108471

8/8/27

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:32:09 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40825

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 08/08/27

①

27.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 08/08/28

②

28.0 POWDER COATING

POWDER COATING



M 106442

1X

③

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

Pb

2- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:45

MJ

08/08/28

29.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MJ

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28

✓

30.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch: B40869

SD 08/08/29

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-769-044 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: LD Date: 08/08/29  
QA: N/C Closed: LD Date: 08/08/29

NCR: 20825		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/29	20.	Durring Assembly of a piece of was found that a masking tape was on D3783-041. R.C. missed Durring inspection	Initial Chief Eng	Remove masking tape. Scuff extra length of tape with 320 grit sand paper	M-f 08/08/29	✓	RB 08/08/29	08/08/29
		cerul mased before Powder coating		Re powder coat as per M-f 08/08/29.	BB 08/08/29	✓	S 08/08/29	08/08/29
				Re inspect QC3		✓	G 08/08/29	08/08/29

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT FACING SEAT ASS'Y RH
Job Number: 40825		Part Number: D412769044
Job Number:		
Seq. #:	Machine Or Operation:	Description :
32.0	D37741	Seat Bottom, LH/RH 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: B 40867	SB
33.0	D37743	Seat Back, LH/RH 
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Back, LH batch: B 40868	SB
34.0	AN525 10R22	Screw 
		
	Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Screw batch: M 107 934	SB
35.0	AN960JD10L	Washer 
		
	Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Washer batch: M 105 793 (or NAS1149D0332J) batch:	SB
36.0	MS21042L3	Nut 
		
	Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s) Nut batch: M 108 701	SB
37.0	AN35A	Bolt 
		
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: M 109 188	SB 08/08/29
38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1- install remaining parts as per dwg D412-769-2	FF 08/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40825

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
39.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>60808129</i>
Comment:	INSPECT WORK TO CURRENT STEP	
40.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>80808129</i>
Comment:	PACKAGING RESOURCE #1	
Identify and Stock		
Location:	<i>Draft P.P. 40825</i>	<i>80808129</i>
41.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>08-08-29</i>
Comment:	FINAL INSPECTION/W/O RELEASE	

Job Completion



*MF 08-08-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

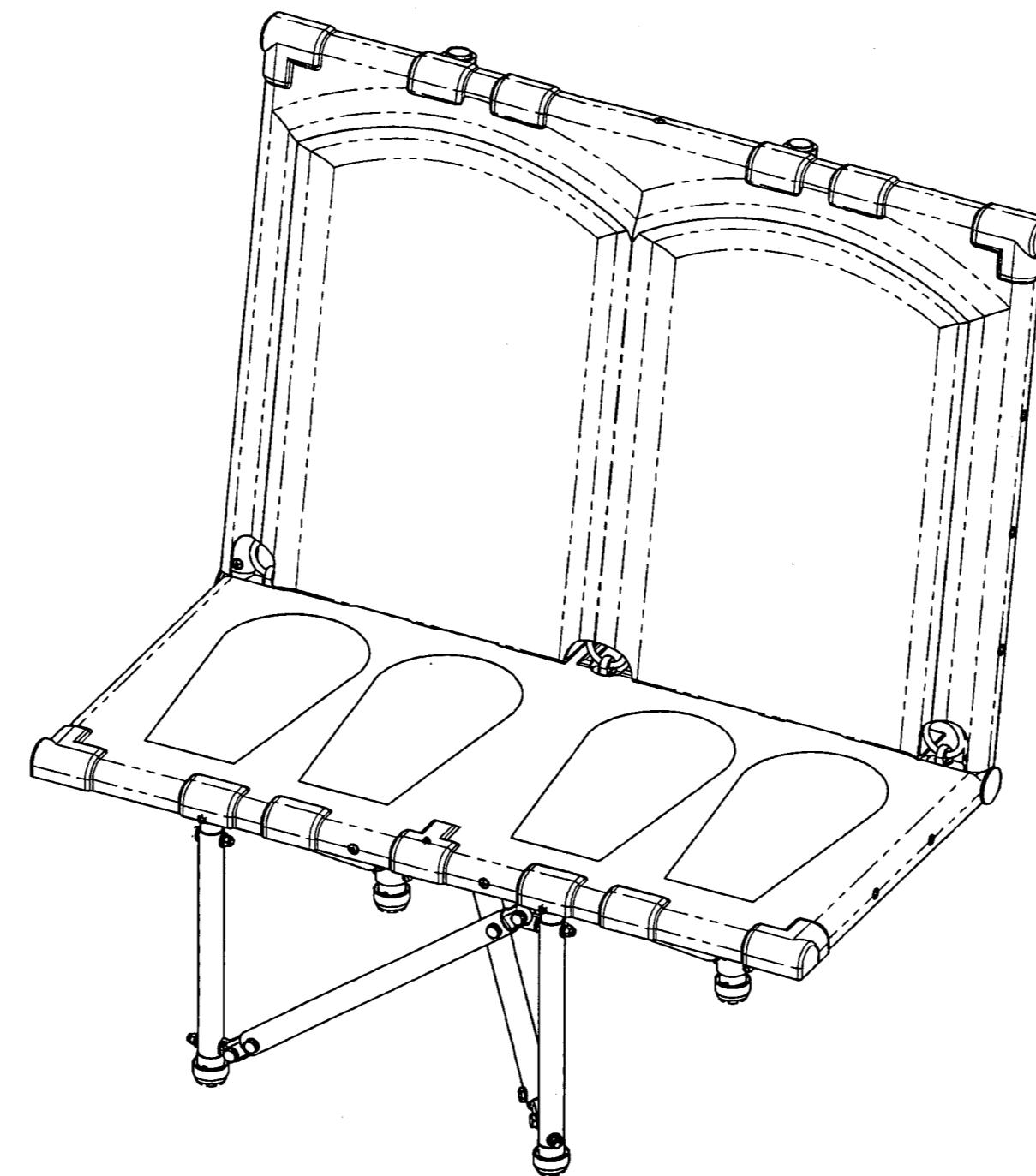
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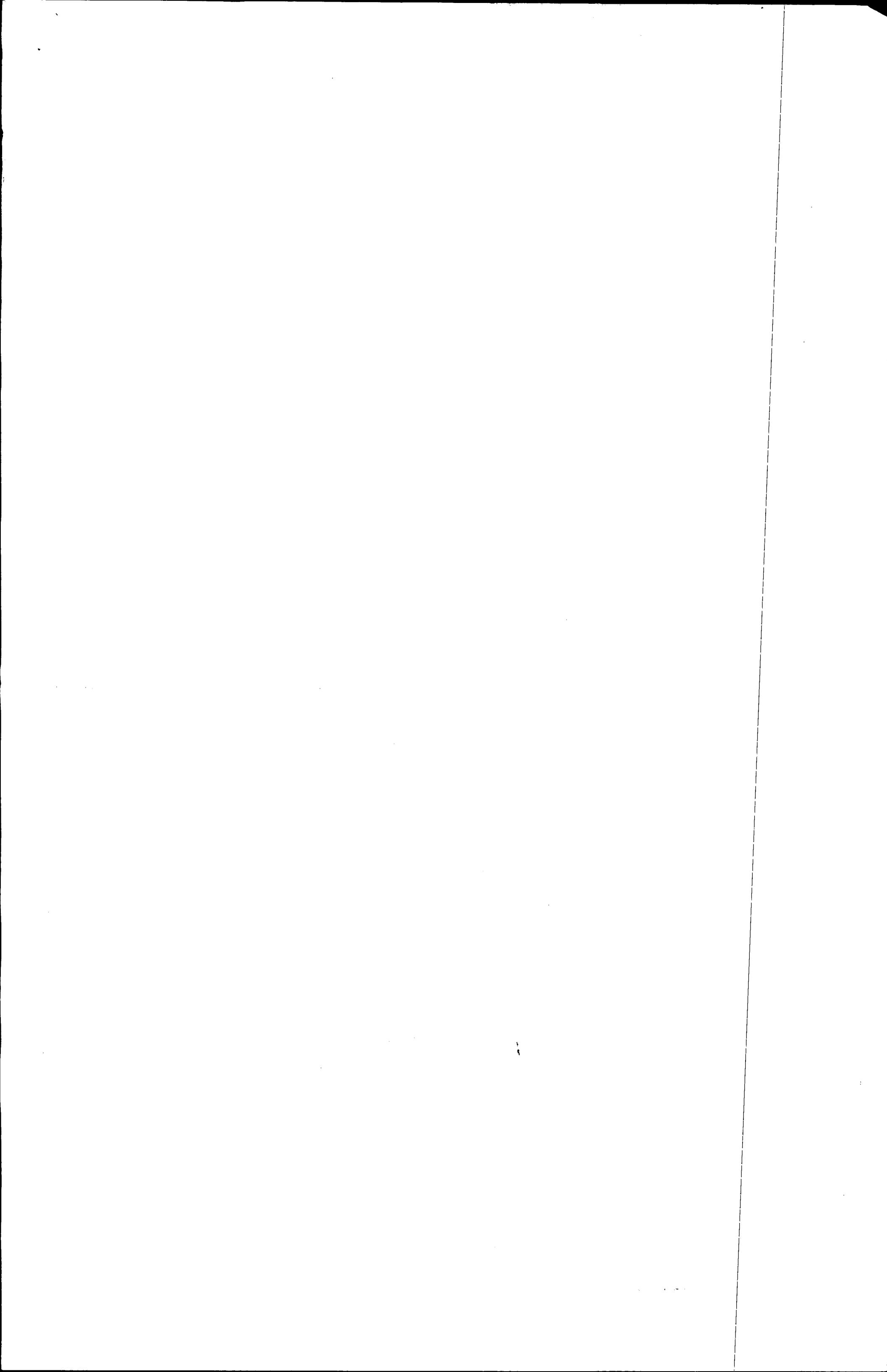
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D412-769-044 AFT FACING SEAT, RH

RELEASED  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40825

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	DRAWING NO.	REV. B
MFG. APPR.	MM	D412-769-2	SHEET 1 OF 7
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	AFT FACING SEAT ASSY, RH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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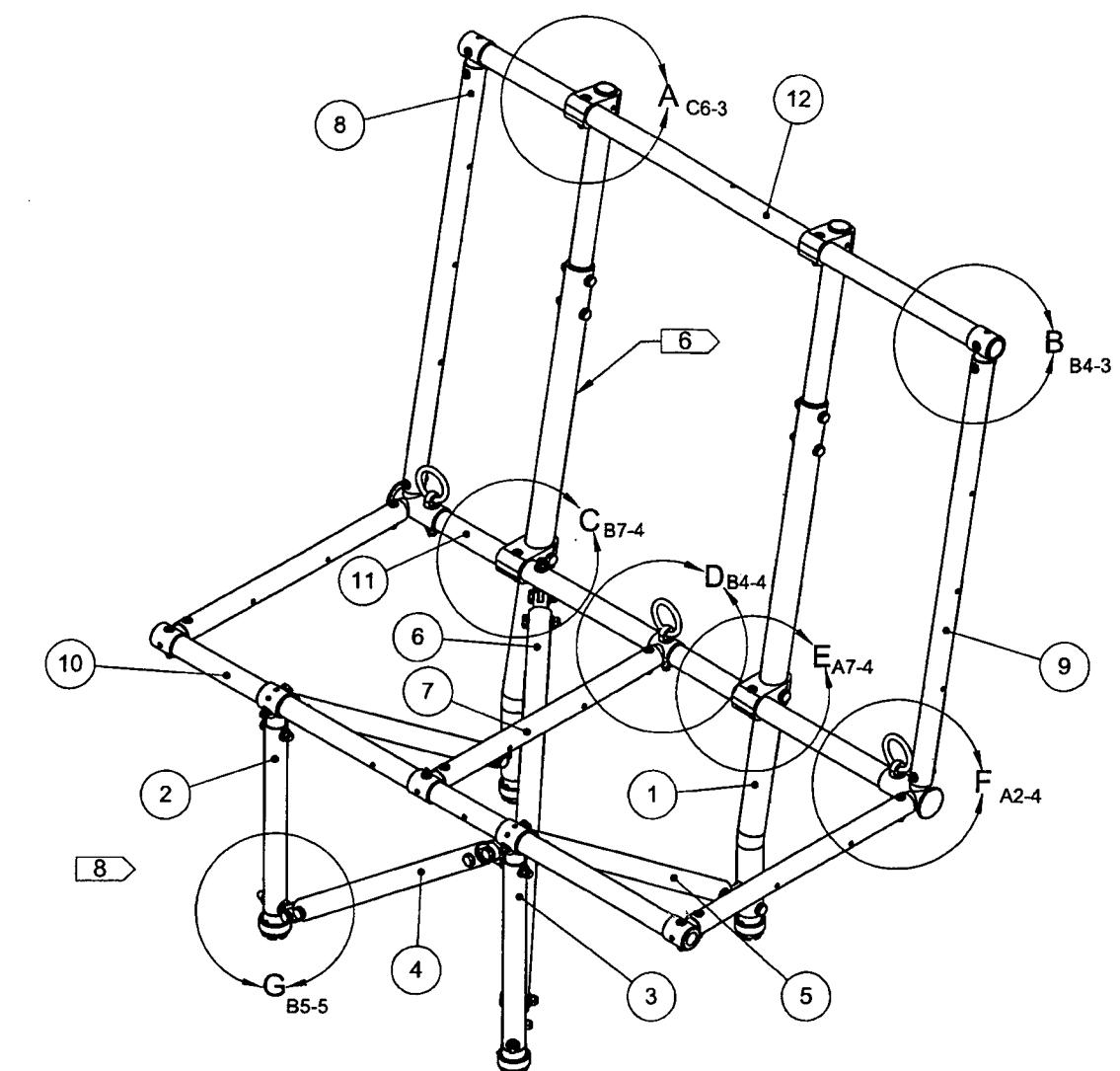
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A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

B



## NOTES:

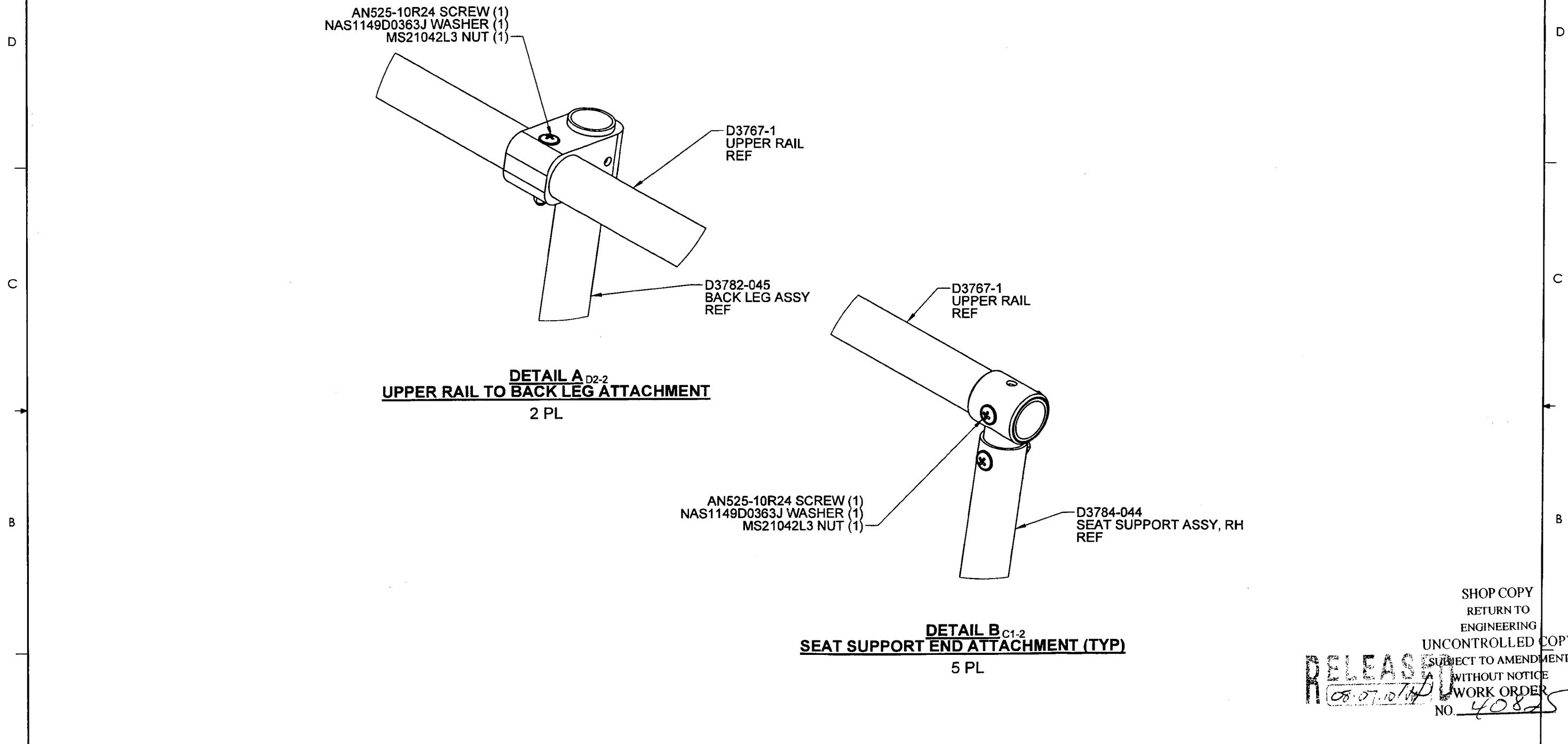
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

D412-769-044 AFT FACING SEAT, RH

RELEASED  
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WITHOUT NOTICE  
WORK ORDER  
NO. 40825

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D412-769-2 REV. B SHEET 2 OF 7 TITLE SCALE NTS
DRAWN	HS	
CHECKED	✓	
MFG. APPR.	✓	
APPROVED	✓	
DE APPR.	✓	
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WORK ORDER  
NO. 40825

DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D412-769-2
MFG. APPR.	M	REV. B
APPROVED	M	SHEET 3 OF 7
DE APPR.	M	TITLE
DATE	08.06.25	SCALE NTS

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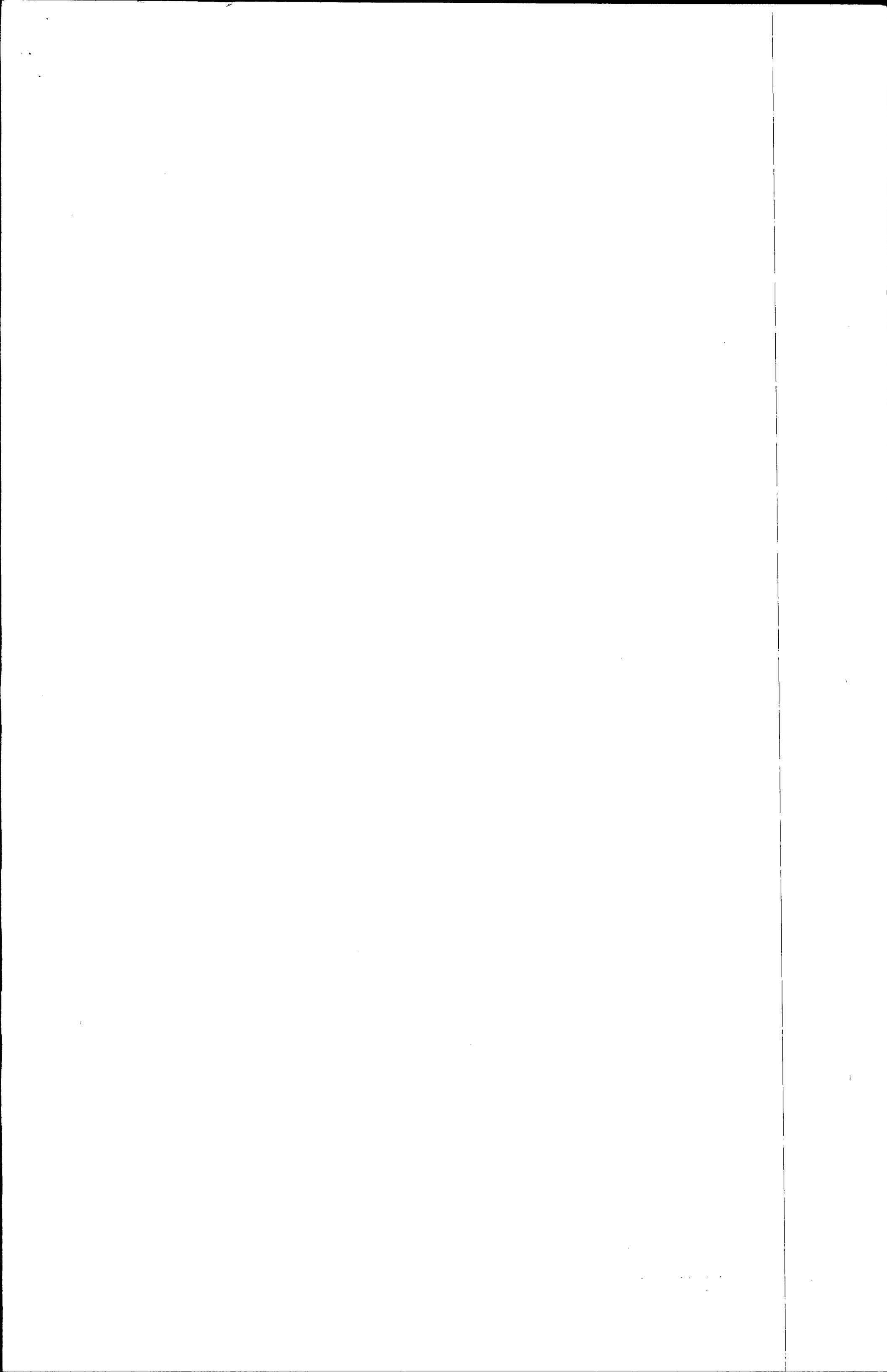
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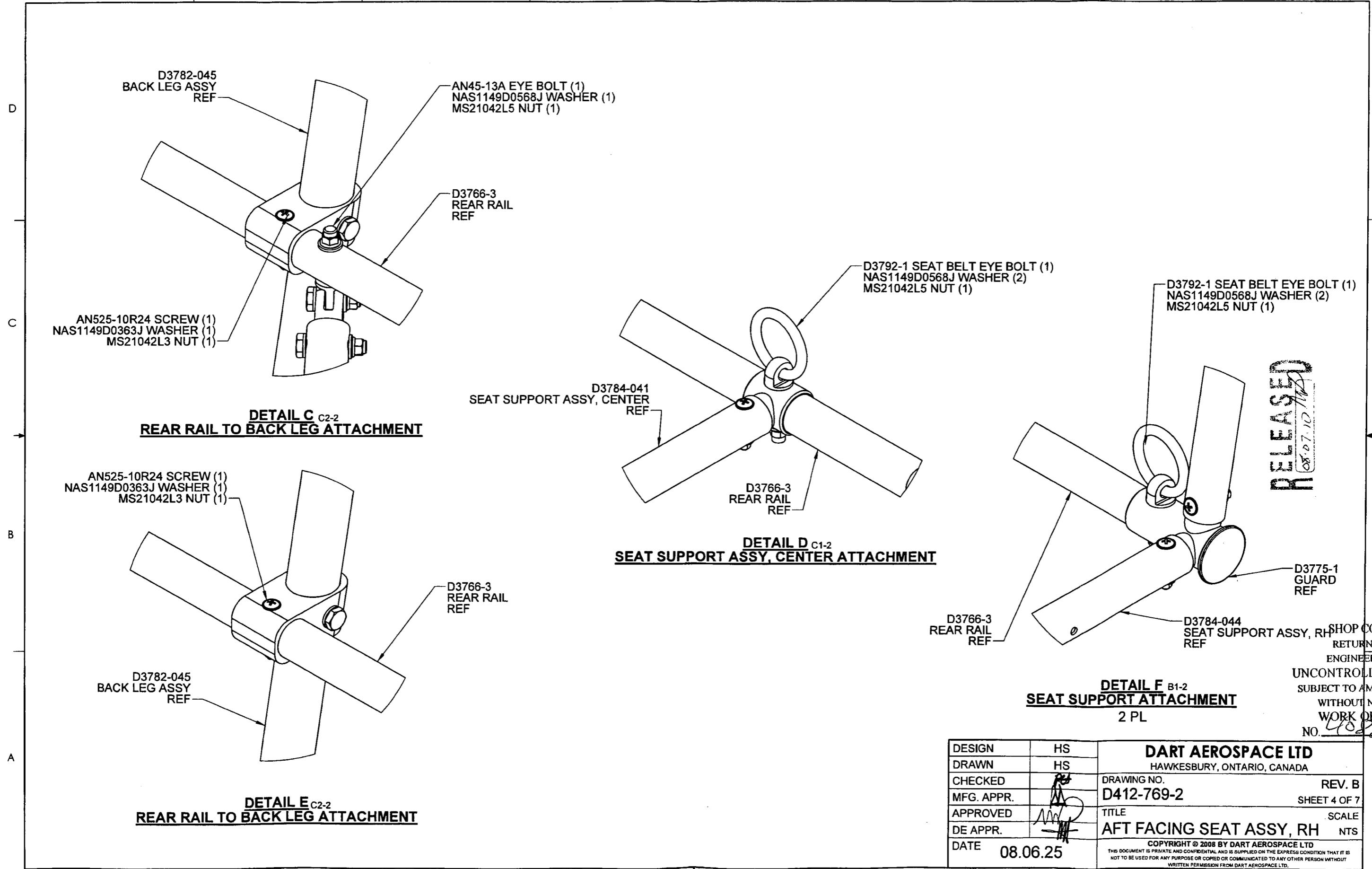
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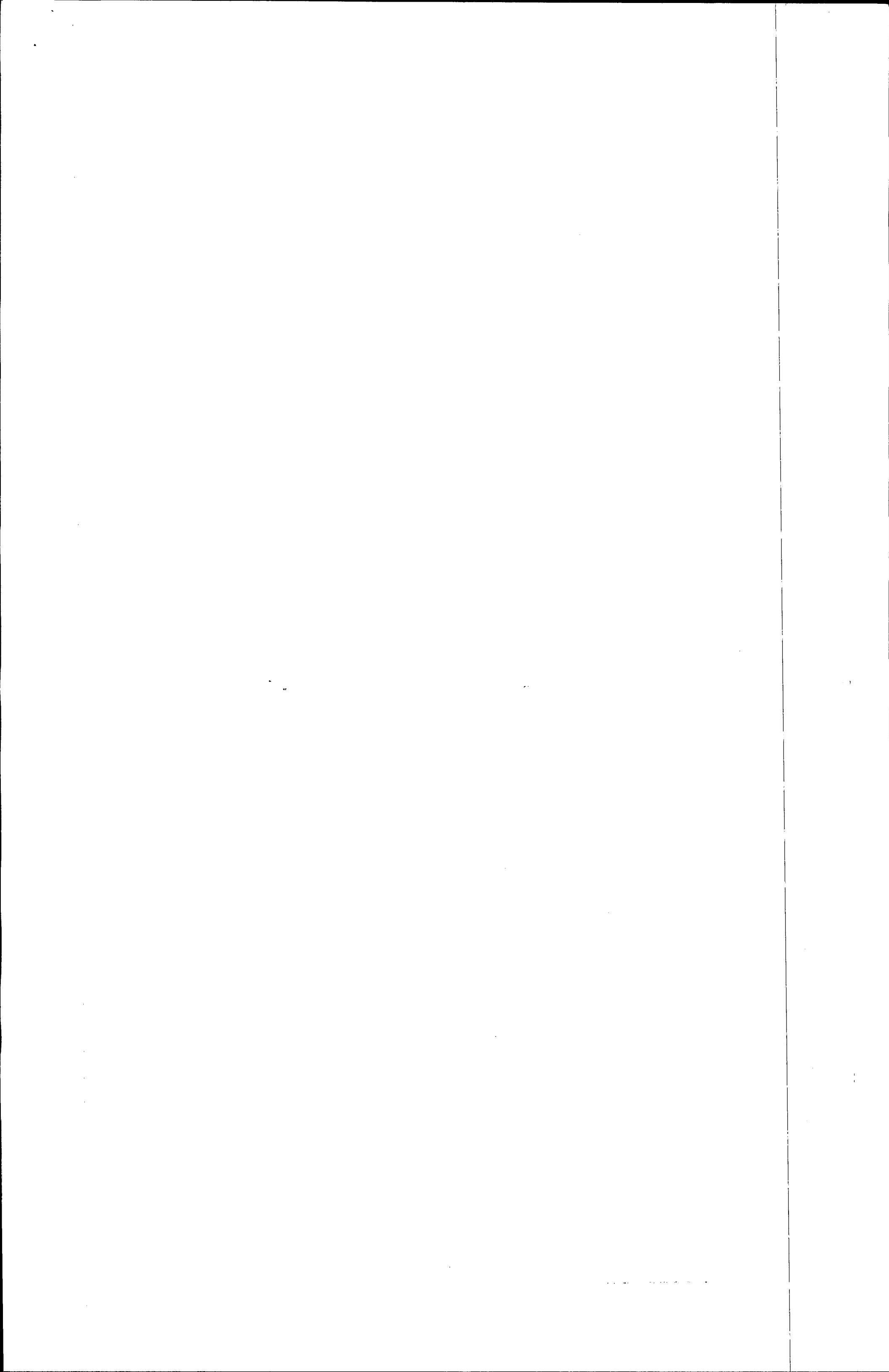
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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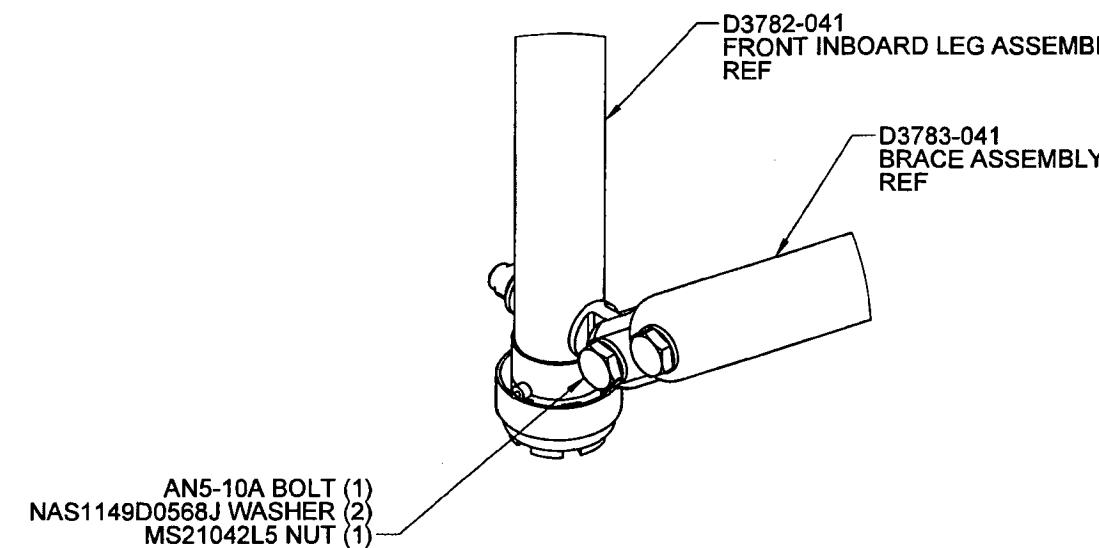
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**DETAIL G<sub>B3-2</sub>**  
**BRACE ATTACHMENT**  
6 PL

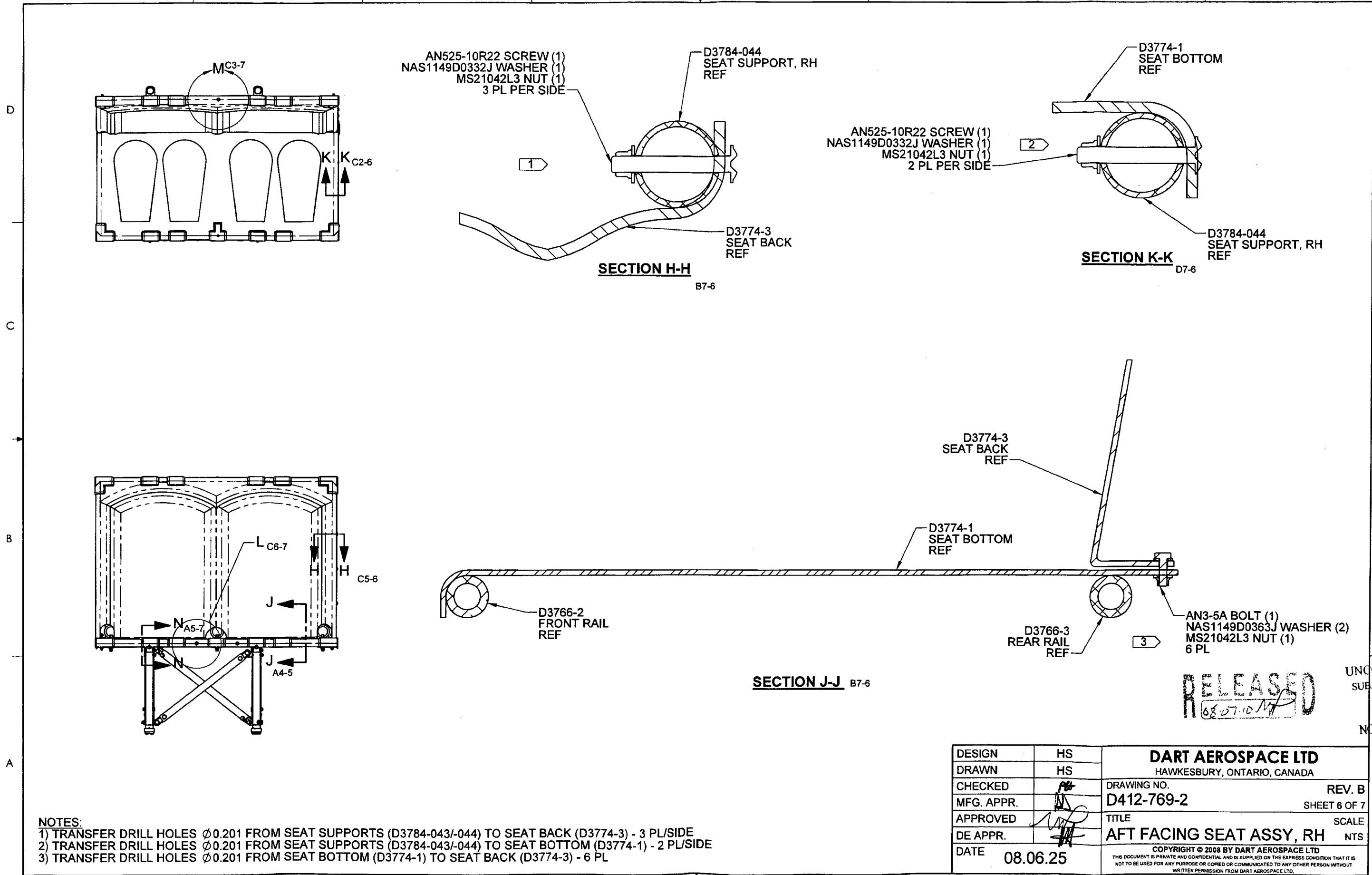
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WITHOUT NOTICE  
WORK ORDER  
NO. 4082

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	RE	
MFG. APPR.	MM	
APPROVED	MM	
DE APPR.	MM	
DATE	08.06.25	REV. B D412-769-2 SHEET 5 OF 7 TITLE SCALE AFT FACING SEAT ASSY, RH NTS

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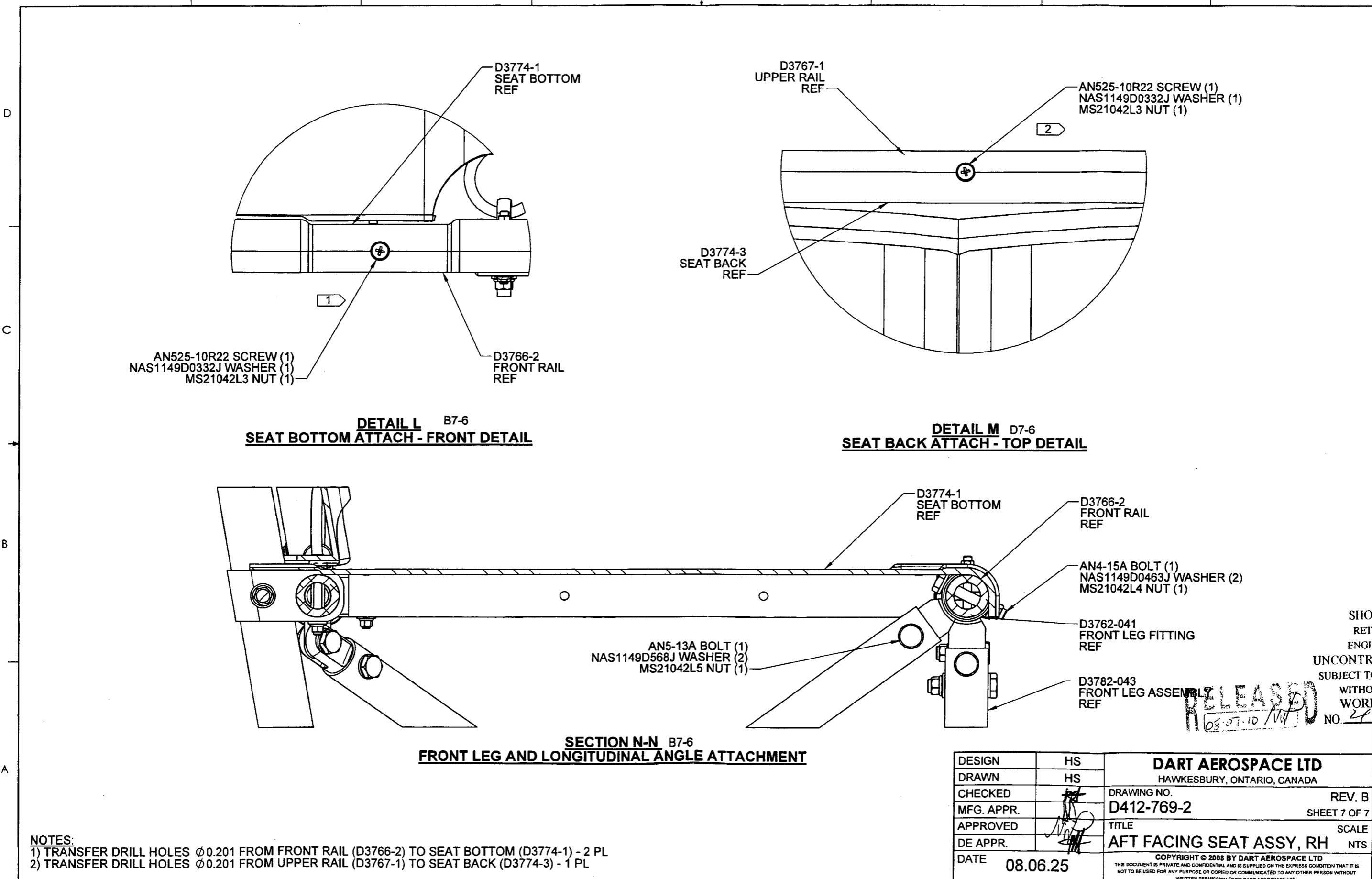
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	
MFG. APPR.	<i>AS</i>	D412-769-2	
APPROVED	<i>AS</i>	REV. B	
DE APPR.	<i>AS</i>	SHEET 6 OF 7	
DATE	08.06.25	TITLE	
		AFT FACING SEAT ASSY, RH	
		SCALE NTS	
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